CLAIMS

We claim:

1.   A variable folder having a product strand path extending therethrough, said variable folder comprising:

a cross-cutting arrangement including a cutting cylinder and at least one cutting blade carried on said cutting cylinder functional for cutting a product from a feeding web strand fed along the product strand path, said at least one cutting blade having a plurality of recesses functioning to leave residual crosspieces in said feeding web strand by which said product remains connected to said feeding web strand;

a collecting cylinder located downstream of said cross-cutting arrangement along the product strand path;

a product directing arrangement which leads from said cross-cutting arrangement to said collecting cylinder; and

accelerating and tearing-off cams at a location between said cross-cutting arrangement and said collecting cylinder through which said product passes, said accelerating and tearing-off cams operable for gripping said product to tear off said product from said feeding web strand at said residual crosspieces.

2.   A variable folder according to claim 1, wherein said cutting blade has three recesses, said recesses being arranged to register with border regions and a center of said feeding web strand.

1   3.   A variable folder according to claim 1, wherein each residual crosspiece

2 has an accelerating and tearing-off cam associated therewith.

1   4.   A variable folder according to claim 1, wherein said accelerating and

2 tearing-off cams are arranged to register with print-free regions of said feeding web strand.

1   5.   A variable folder according to claim 1, further comprising first and

2 second drawing arrangements arranged one after another upstream of said cross-cutting

3 arrangement, said first and second drawing arrangements each operating at a circumferential

4 speed which is greater than a speed of said feeding web strand received from upstream printing

5 units by a lead which is adjustable.

1   6.   A variable folder according to claim 5, further comprising a third

2 drawing arrangement arranged between said cross-cutting arrangement and said accelerating

3 and tearing-off cams, said third drawing arrangement being operable at the circumferential

4 speed of said first and second drawing arrangements.

1   7.   A variable folder according to claim 6, wherein said accelerating and

2 tearing-off cams are operable at a higher circumferential speed than the circumferential speed

3 at which said first, second and third drawing arrangements are operable.

1   8.   A variable folder according to claim 1, further comprising a driven

2 roller, said accelerating and tearing-off cams interacting with said driven roller.

1   9.   A variable folder according to claim 8, wherein a ratio of a speed of said

2   driven roller to a speed of said accelerating and tearing-off cams is other than a whole number.

1   10.   A variable folder according to claim 1, wherein said product-directing

2   arrangement comprises a belt directing system which in operation is product non-engageable.

1   11.   A variable folder according to claim 1, wherein said product-directing

2   arrangement comprises tongues.

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